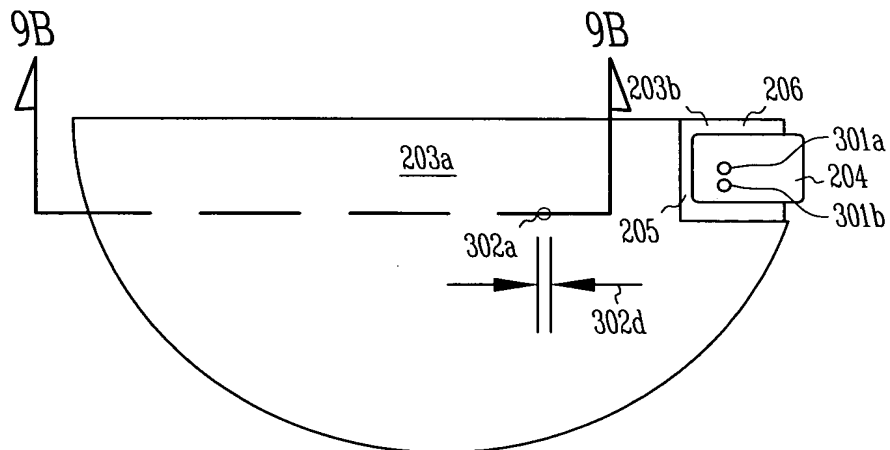
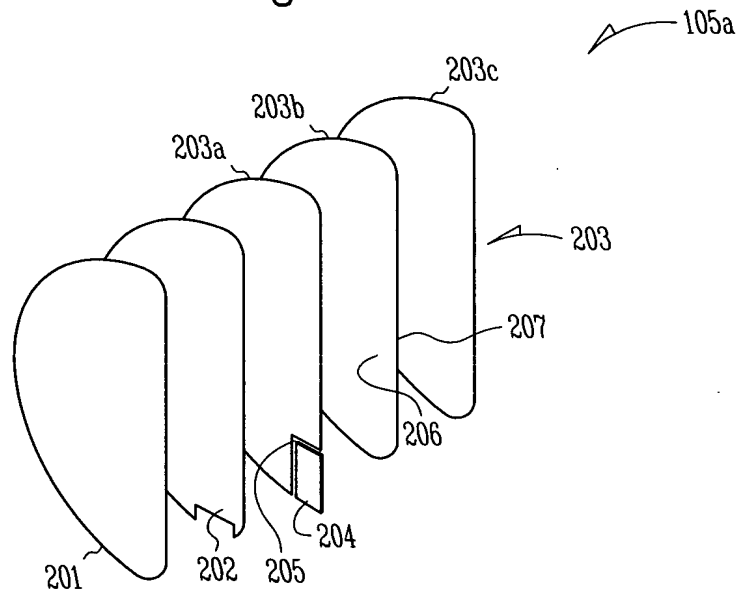
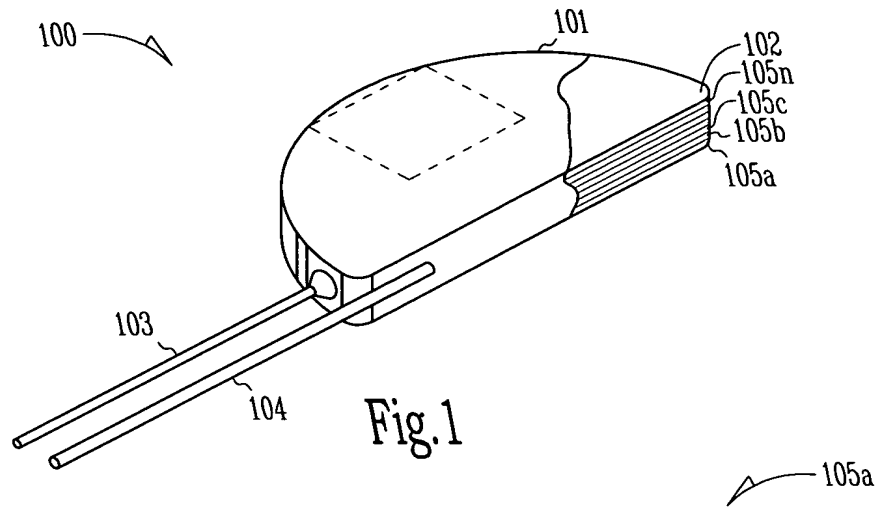


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Fig.4

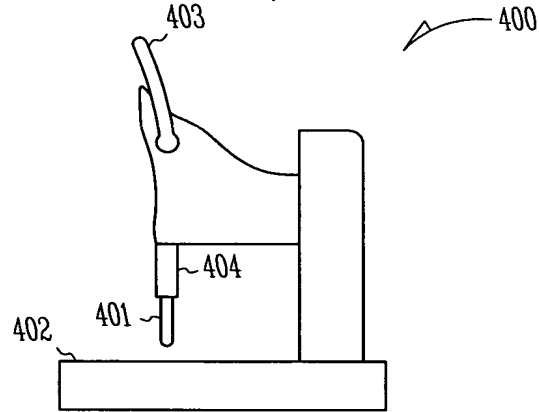


Fig.5

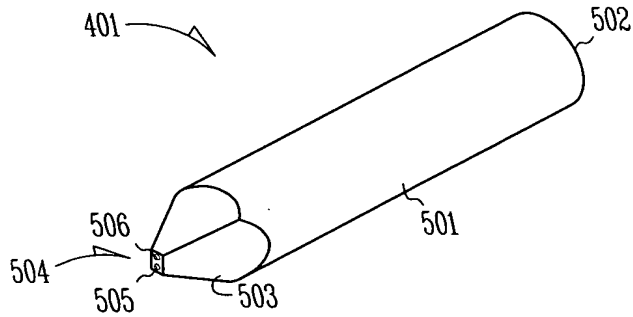


Fig.6

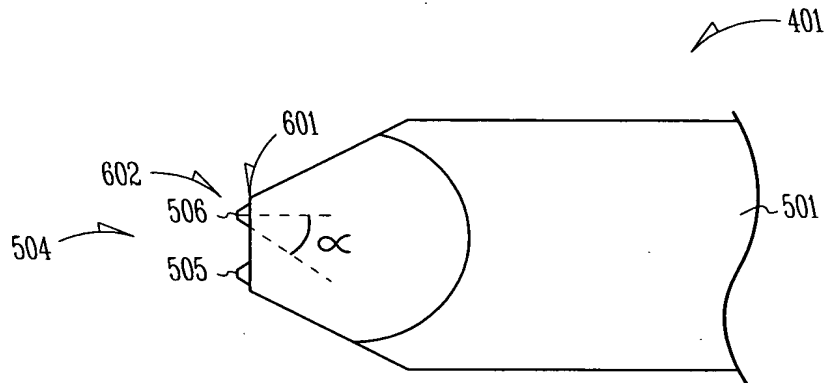
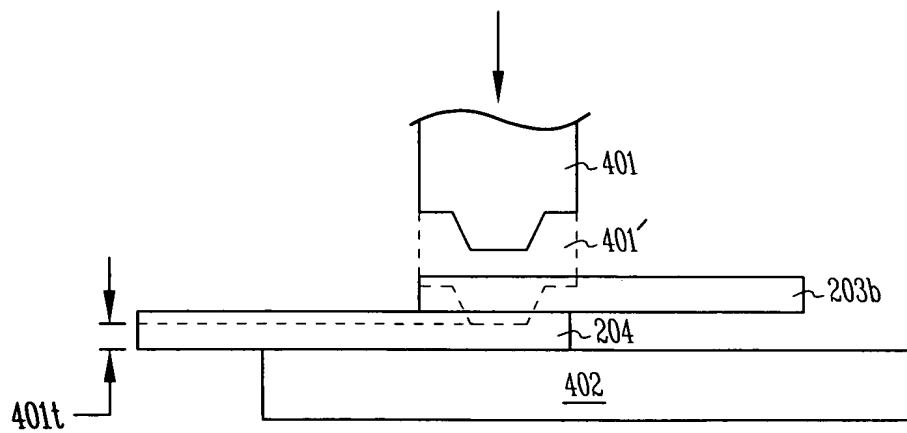



Fig.7



600 

SETTING THE STAKING MACHINE 610

STACKING THE FOIL AND THE
CONNECTION MEMBER 620

STAKING THE FOIL AND THE
CONNECTION MEMBER TOGETHER 630

Fig.8

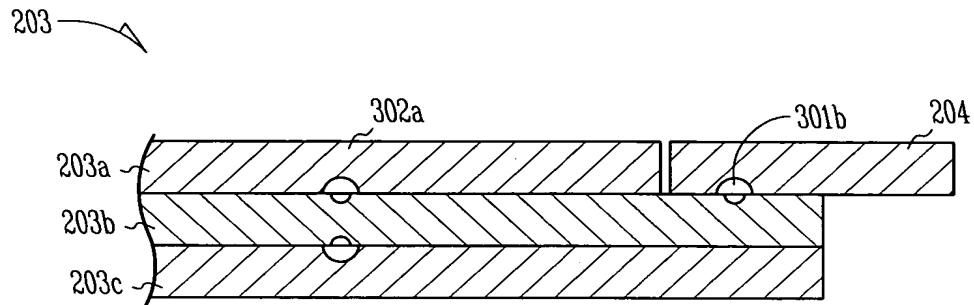


Fig. 9A

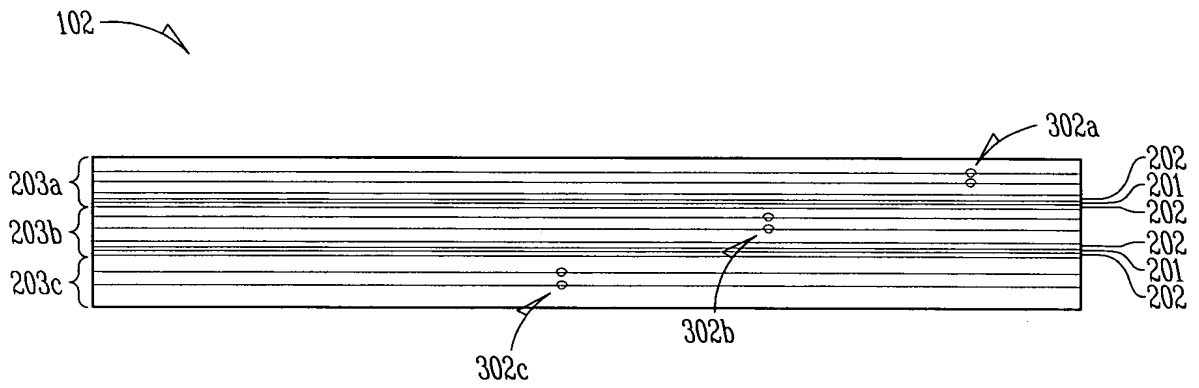


Fig. 9B

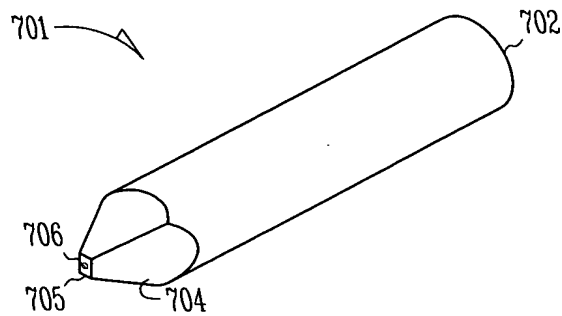



Fig. 10

700 

SETTING THE STAKING MACHINE ~710

STACKING THE FOILS ~720

STAKING THE FOILS TOGETHER ~730

Fig.11

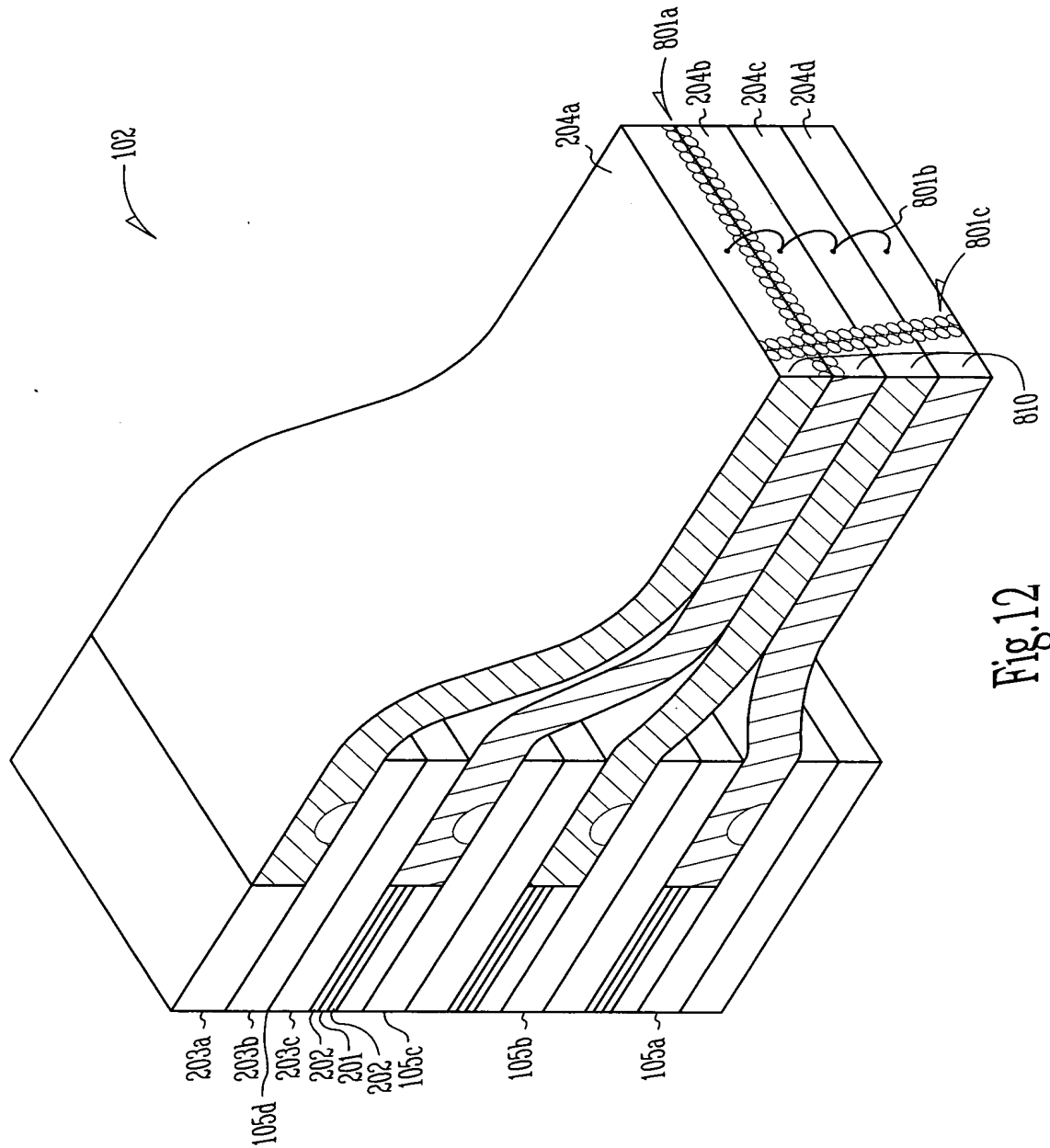


Fig. 12

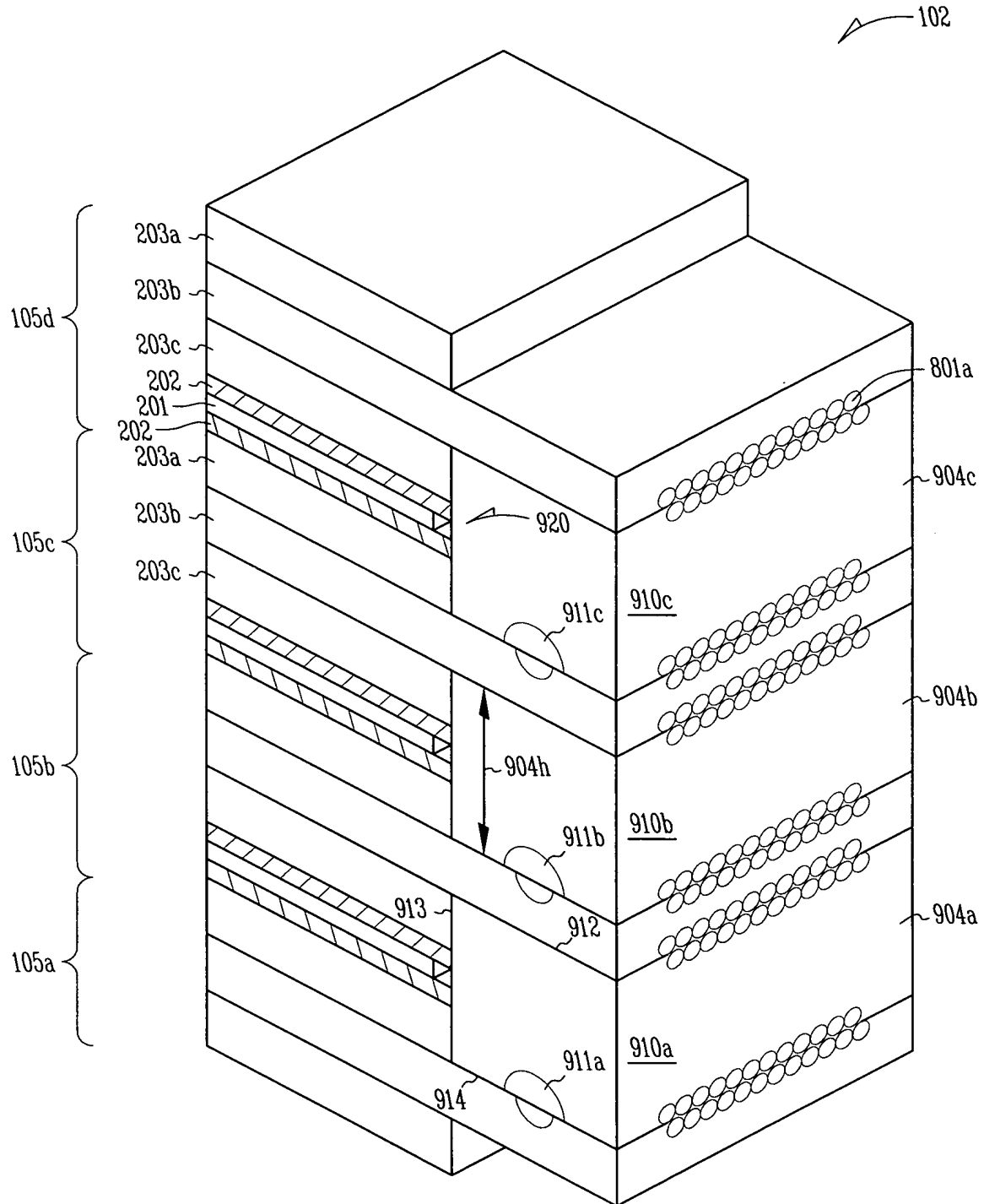


Fig.13

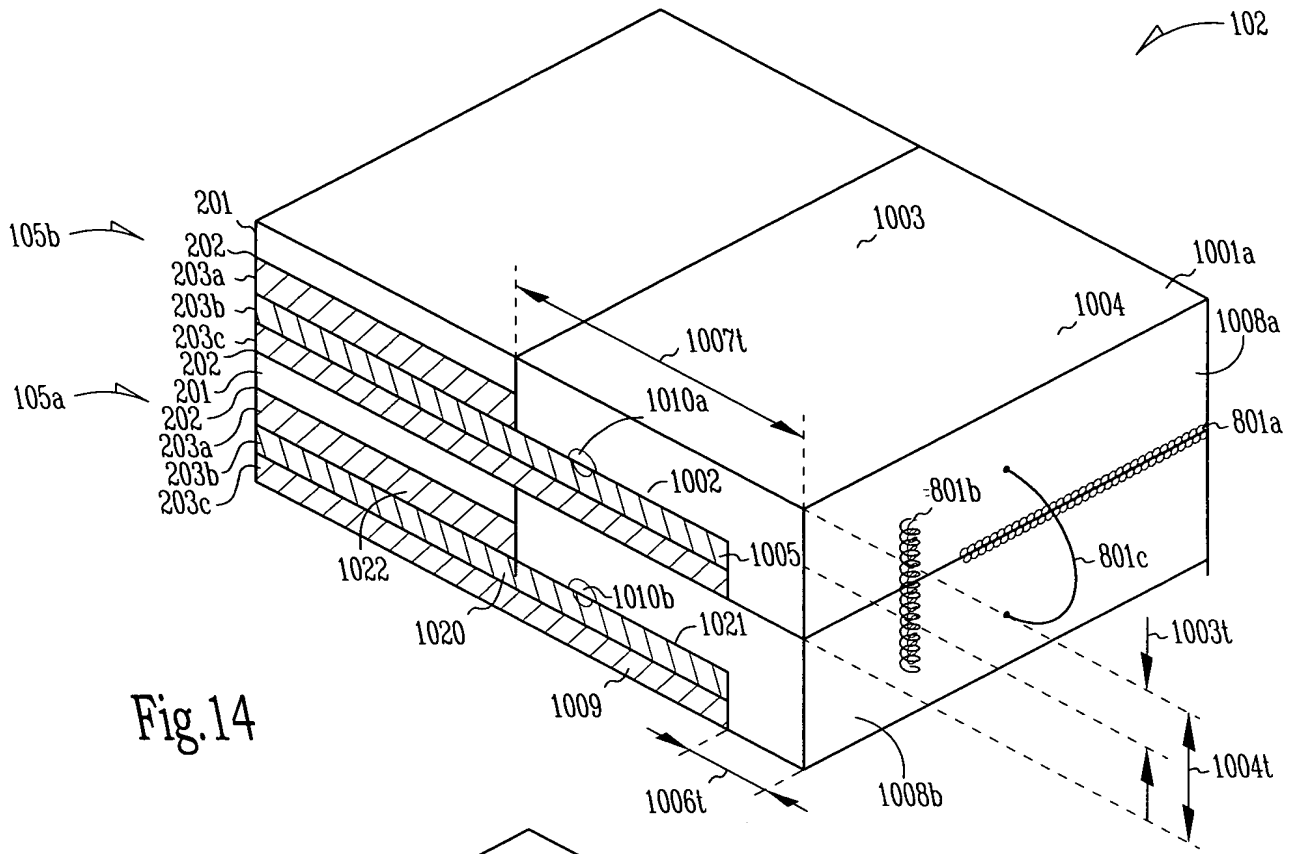


Fig. 14

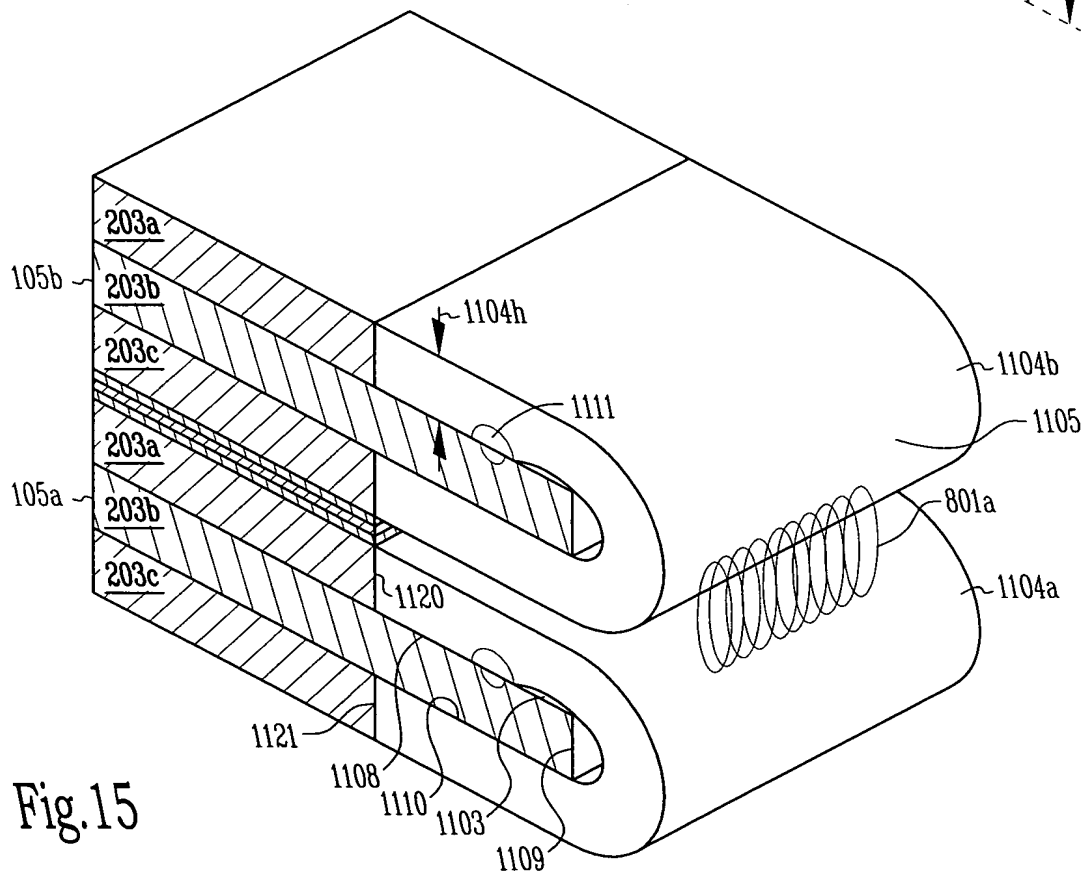


Fig. 15

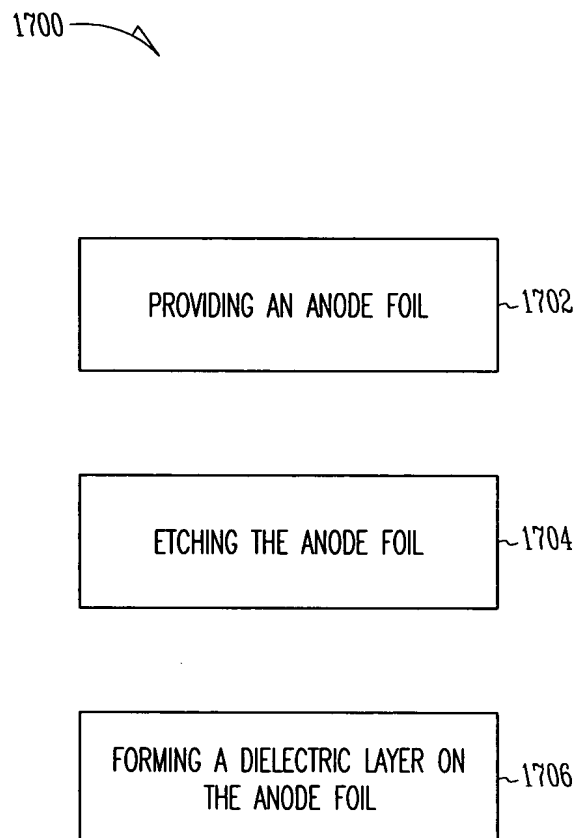


Fig.17

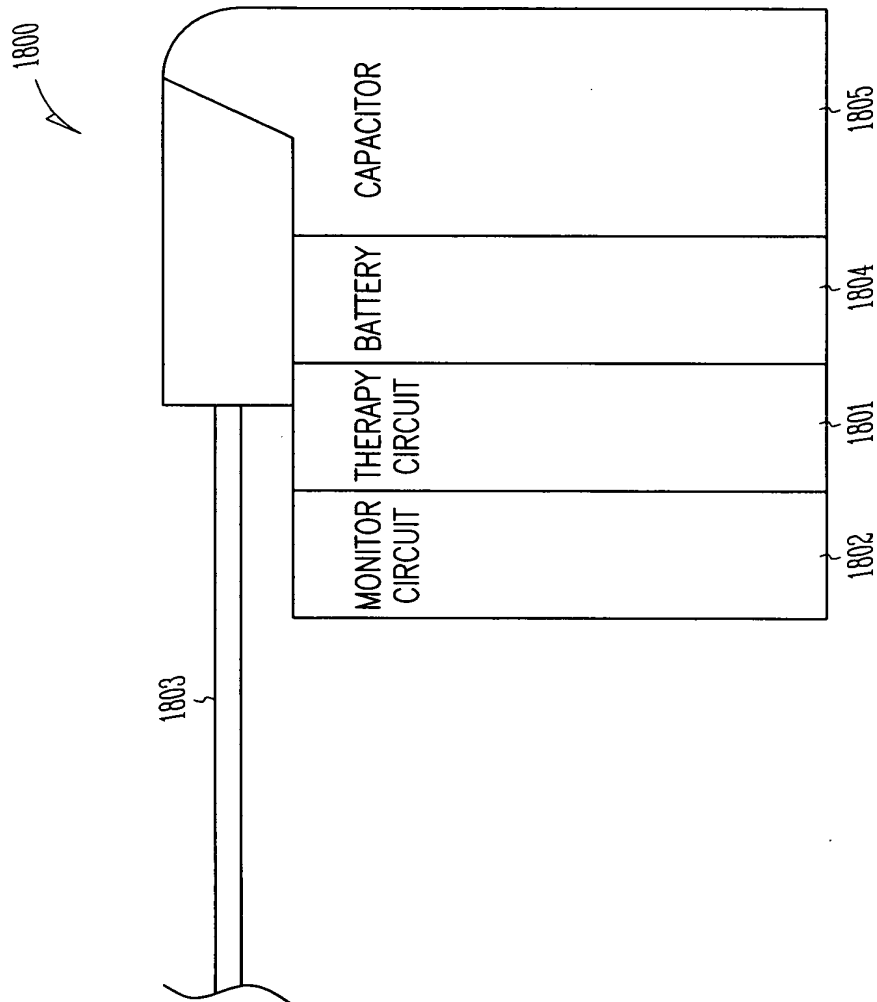


FIG. 18